

1 **51216/DAD/W112 -**

ABSTRACT OF THE DISCLOSURE

5 A method for attaching a ring electrode to the shaft of the tip section of a
catheter comprises passing an electrode lead wire through a lumen in the
catheter and out an exit hole in the tip section. The portion of the electrode lead
wire extending out of the exit hole is stripped of non-conductive coating and
wrapped around the shaft and secured in a clove hitch arrangement. The
10 wrapped electrode lead wire is pulled tight while the material of the shaft is
heated to embed the electrode lead wire in the shaft so that its outermost surface
is generally flush with the surface of the shaft. The exit hole is sealed and a ring
electrode, having a flared skirt is slipped over the shaft to a position over the
wrapped electrode lead wire and exit hole. It is then swaged to reduce its outer
15 diameter to about that of the outer diameter of the shaft of the tip section to
thereby create a low ohmic connection with the electrode lead wire.

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